

Work Order ID 130782

130782

Page 1

Wednesday, March 25, 2015 11:30:31 AM

Item ID: D5092-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 3/25/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 3/25/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 1503-25 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5092	B								

110 0.00
110 10 ~~Ø~~ Jm15-3-25
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut D5092-1 as per Dwg
6061-080" Dwg Rev: B
Prog Rev: 3
2-Deburr if necessary

120 0.00
120 10 ~~Ø~~ Jm15-3-25
QC Memo 0.00
Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Handling/Pre									
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Offset/Setup									
Process									
Supplier									
Training									
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130782

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Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 3/25/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 3/25/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>27987</u>								
	1- Black Anodize as per Dwg NOTE 2								
	Certification of Conformity is required								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

CX APR 10 2015 10

10x 8015-01-24

10 APR 24 2015 DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Start Date: 3/25/2015 Start Qty: 10.00 ***10*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170						10x			15/04/27
Small Fab	Memo	0.00							
Small Fab	INSTALL NUT PLATE AS DWG								
180		0.00							
180						10			DAS 38 9-89
QC	Memo	0.00							
Quality Control	QC5- Inspect part completeness to step on W/O								APR 27 2015
190		0.00							
190						10			DAS 38 9-89
Packaging	Identify as per dwg & Stock Location: ST147	0.00							
Packaging	Memo	0.00							APR 27 2015

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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 130782***130782***

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Start Date: 3/25/2015 Start Qty: 10.00 ***10*** Cust Item ID:
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-28
MF
15-4-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Page 1

Wednesday, March 25, 2015 11:30:34 AM

Work Order ID: 130782

130782

Parent Item: D5092-041

D5092-041

Parent Item Name: Doubler Assembly

Start Date: 3/25/2015

Required Date: 3/25/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.11.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

sf

211.1918

1

M6061T6S 080

**

Jm15-3-25

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT020

211.1918

m130530

45.5

m130560

165.6918

130560

MS20426AD3-4

Purchased

No

Each

5,088.000

80

MS20426AD3-4

**

DAS
36
9-89

RIVET

Location

Loc Qty

Loc Code

CA

12

125578

12

MF4

19

125578

19

ST312A

4000

m131697

4000

80

ST313

1057

m127432

1057

MS21069L08

Purchased

No

Each

793.0000

40

MS21069L 08

**

DAS
36
9-89

ANCHOR NUT

Location

Loc Qty

Loc Code

ST301

793

123522

793

40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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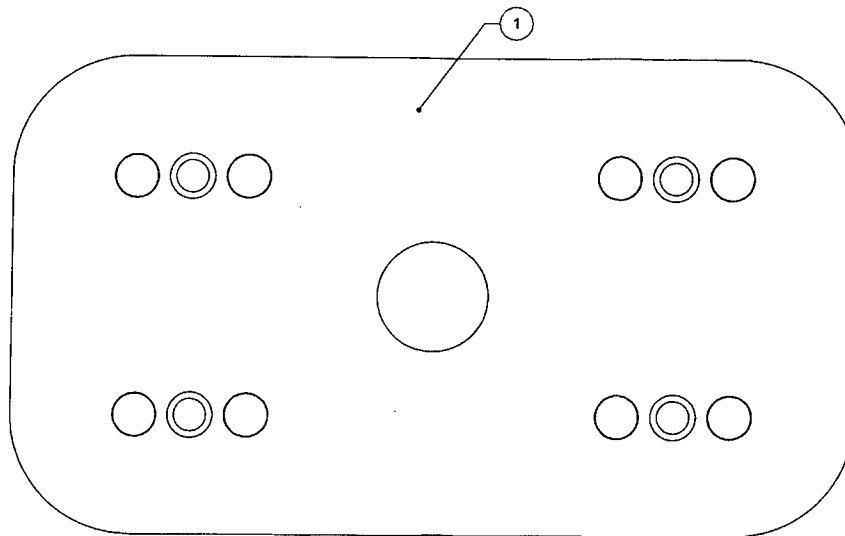
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Material									
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Transport									
Unapproved									

FAULT CATEGORY

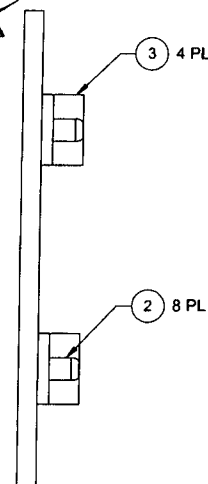
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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ITEM	QTY	P/N	DESCRIPTION
	X	D5092-041	DOUBLER ASSY
1	1	D5092-1	DOUBLER
2	8	MS20426AD3-4	RIVET, SOLID, CSK
3	4	MS21069L08	NUT PLATE, SELF-LOCKING



D5092-041 DOUBLER ASSY

130782 MJS
150325

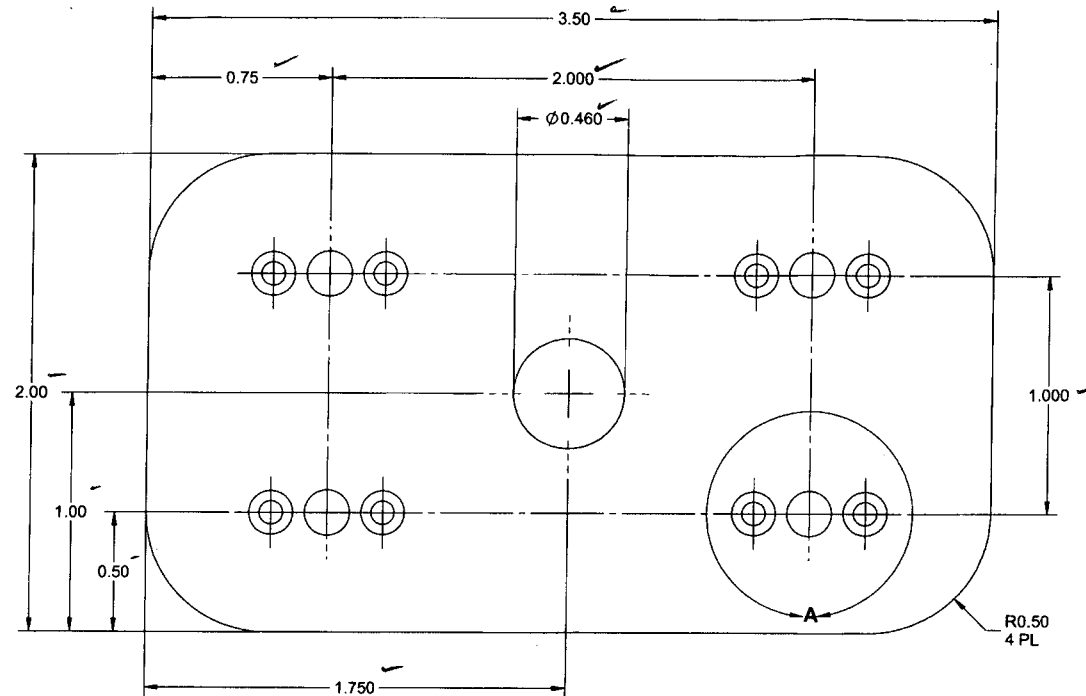


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
 - 7) WEIGHT: 0.05 lbs

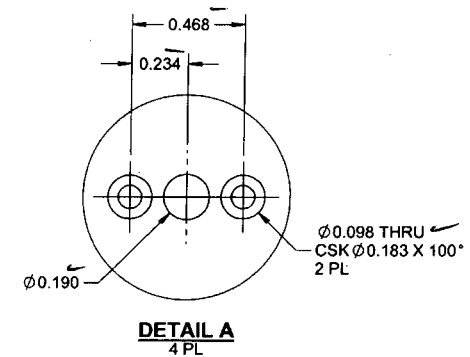
RELEASED
2014-11-06

B	MODIFIED DESIGN TO FACILITATE SIMPLER INSTALLATION OF CONTROL CABLE.	ML	14.07.07
A	NEW ISSUE	ML	14.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5092	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	14.07.07	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



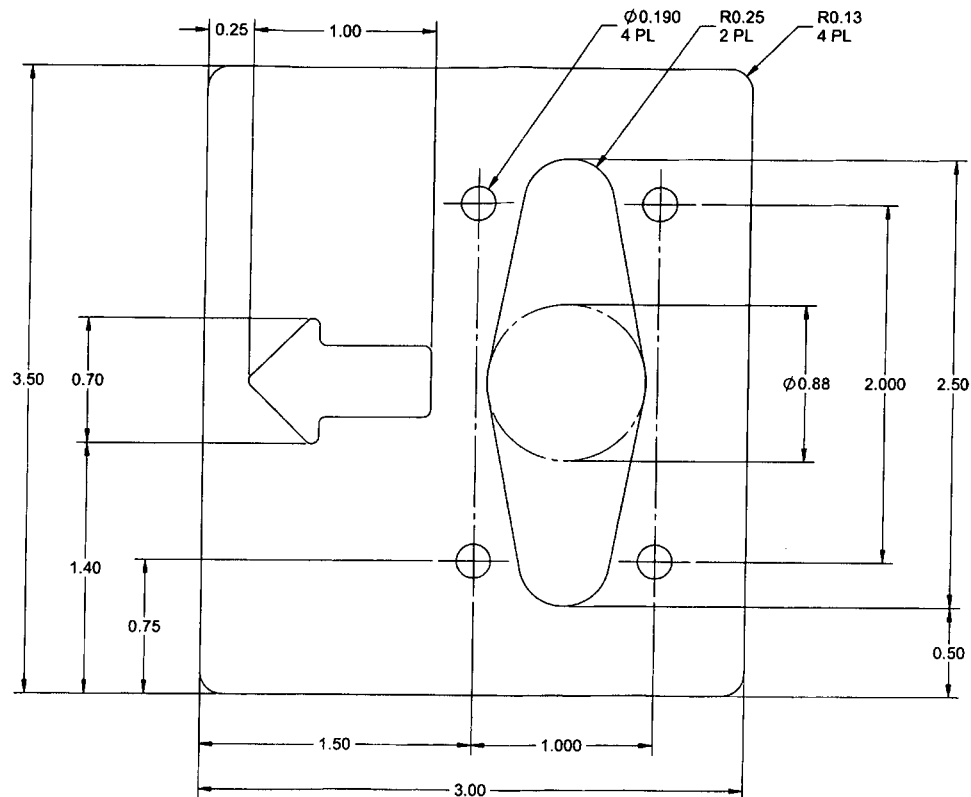
D5092-1 DOUBLER



- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
 - 2) FINISH: ANODIZE BLACK OER MIL-A-8625, TYPE II, CLASS II
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

RELEASED
2014-11-06

APPROVED	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AJS		
	CHECKED	AP	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5092	SHEET 2 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS-4	DOUBLER	NTS
	DATE	14.07.07		
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D5092-1 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.03 lbs
- 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE D5092-3-REVB.DXF
- 9) GRAIN DIRECTION NOT CRITICAL

APPROVED	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AJS		
	CHECKED	AP	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5092	SHEET 3 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	DOUBLER	NTS
DATE		14.07.07	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-11-06



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27987**

Purchase Order Date 4/1/2015

PO Print Date 4/16/2015

Page Number 1 of 8

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	130782	D5092-041 DOUBLER REV. B	4/24/2015 Yes 4/24/2015		10.00	\$1.25	\$12.50
FINISH: HARD BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2							
Line Total:							\$12.50
2	128426	646.3012 LOWER GUIDE REV. N/C	4/24/2015 Yes 4/24/2015		4.00	\$19.90	\$79.60
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N							
Line Total:							\$79.60

89501-24

Note:

4/16/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: D5092-041 DOUBLER ASSEMBLY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150292	Rev: B PO: PO27987	Line: 8015-04-24
4 ea	Part: 646.3012 LOWER GUIDE HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150293	Rev: N/C PO: PO27987	Line:
8 ea	Part: 646.3715 STRUT DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150294	Rev: A PO: PO27987	Line:
3 ea	Part: 646.3812 GUSSET BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150295	Rev: PO: PO27987	Line:
3 ea	Part: 646.3813 STRUT BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER	Rev: N/C	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20150309	PO: PO27987	Line:
2 ea	Part: D4703-043 LOCK PIN HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150310	Rev: A PO: PO27987	 Line:
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>24/4/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			